

Work Order ID 143960-2

March 28, 2016 2:59:29 PM

143960

Page 1

Item ID: D212-725-1-095

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Radius Block

Stop *NS2*

Start Date: 4/4/2016 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals: Process Plan: SA Date: 20160329

Tooling:

Date:

Run Start *NR1*

QC: Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4227	A								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: 1

Prog Rev: 1

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

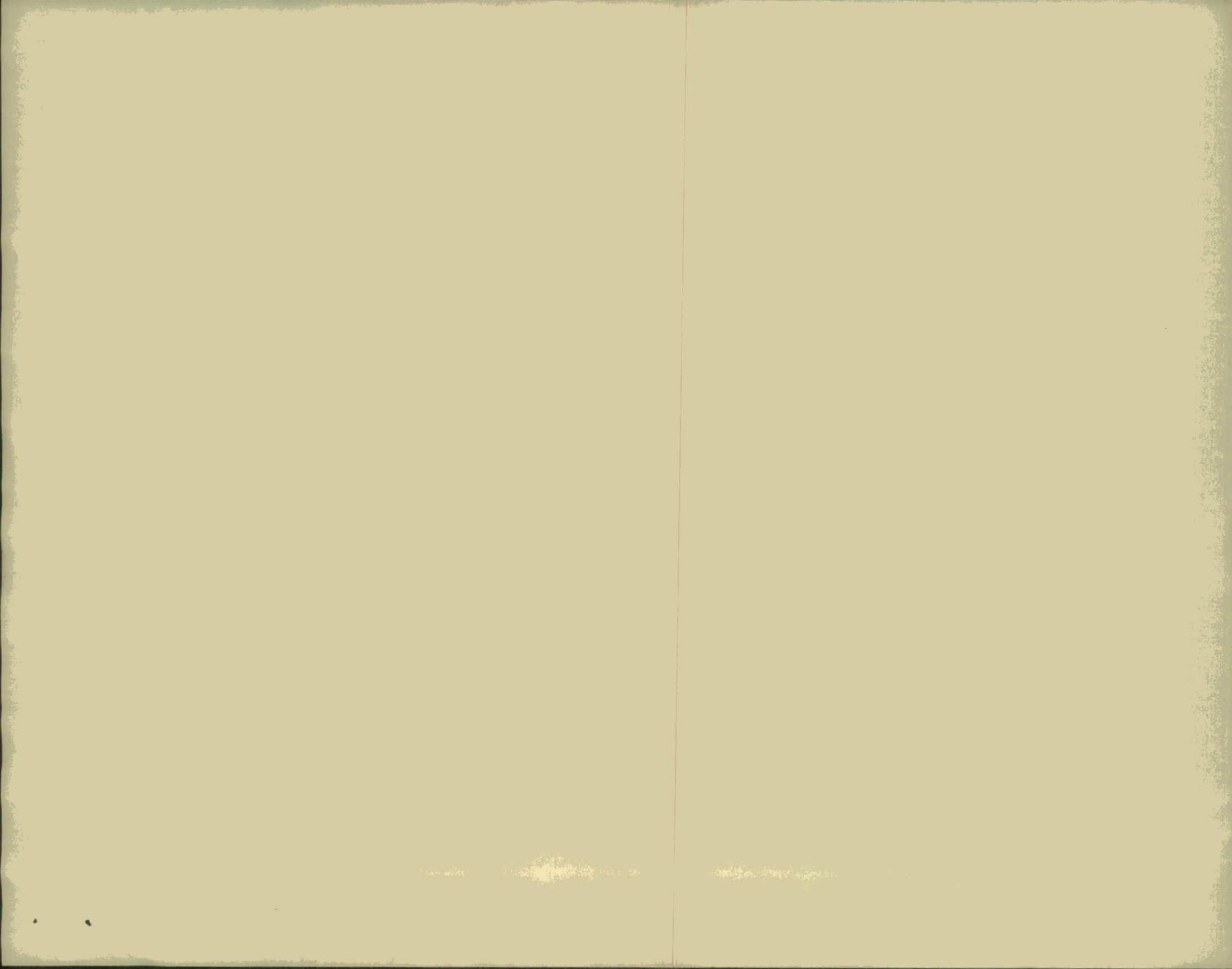
Quality Control

(10)

02/16/03/30

(10)

02/16/03/30



March 28, 2016 2:59:29 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/4/2016 Start Qty: 10.00

10

Customer:

Required Date: 4/14/2016 Req'd Qty: 10.00

10

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

1875

1876

1877

Work Order ID 143960

March 28, 2016 2:59:29 PM

143960

Page 3

Item ID: D212-725-1-095

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Radius Block

Stop ***NS2***

Start Date: 4/4/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	***FLAT PATTERN ONLY***								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>5F174</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

7u of all 16/05/16

(7)

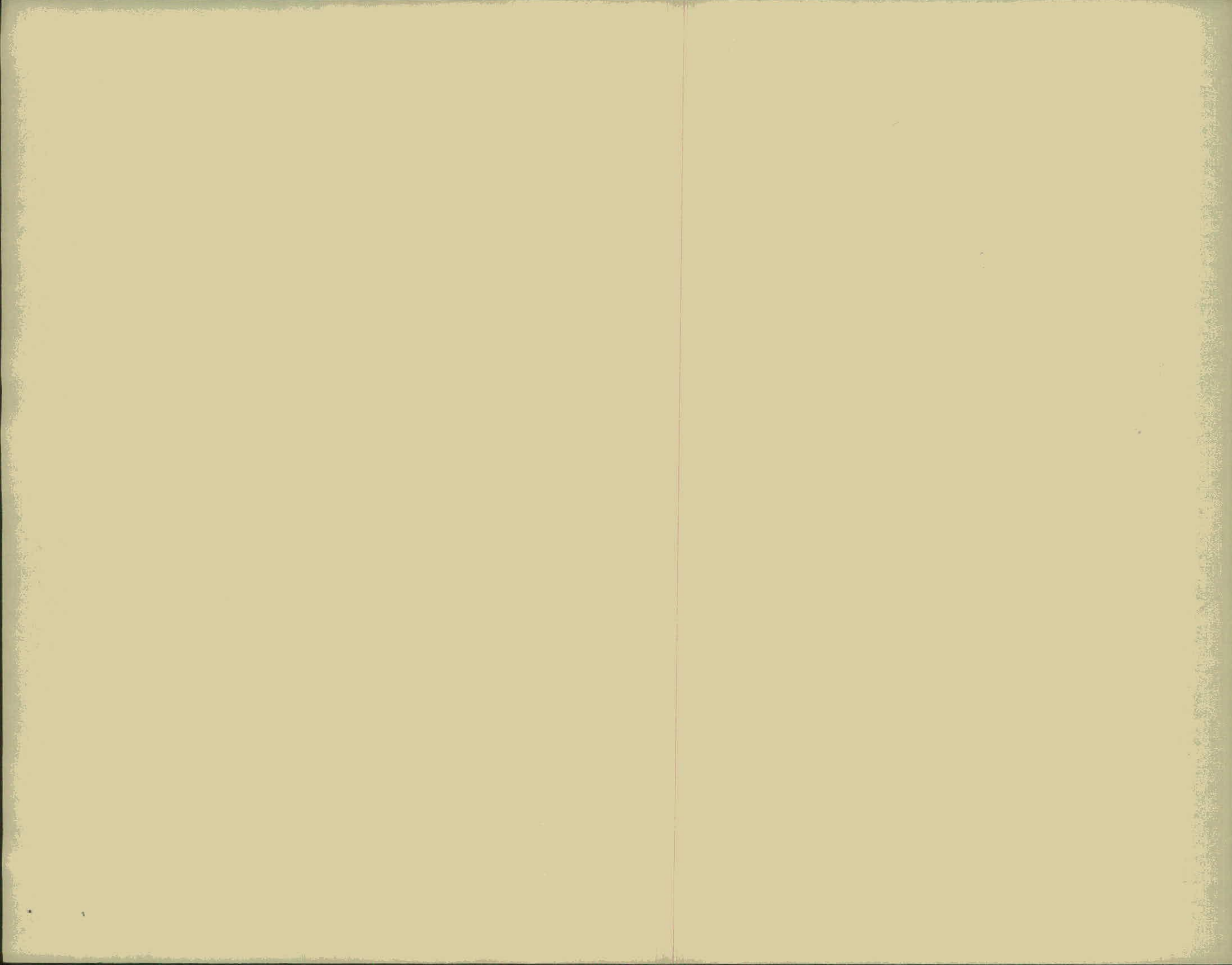
DAS
38
9-89

MAY 05 2016

7

DAS
6
9-89

MAY 06 2016



Work Order ID 143960

March 28, 2016 2:59:29 PM

143960

Page 4

Item ID: D212-725-1-095

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Radius Block

Stop ***NS2***

Start Date: 4/4/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/14/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

20160506
SA

2001-10-10 10:00

RAT 2AT1A0AM

2001-10-10 10:00

10:00

Item ID	Item ID	Item ID
2001-10-10 10:00	2001-10-10 10:00	2001-10-10 10:00

2001-10-10 10:00 2001-10-10 10:00

2001-10-10 10:00 2001-10-10 10:00

2001-10-10 10:00 2001-10-10 10:00

2001-10-10 10:00 2001-10-10 10:00

2001-10-10 10:00 2001-10-10 10:00

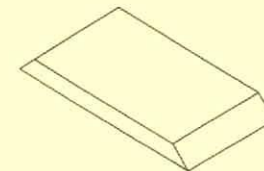
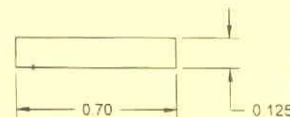
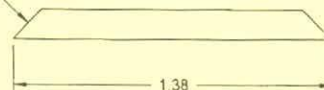
2001-10-10 10:00

D212-725-1-095 RADIUS BLOCK

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6B
OR 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC M6061T6S 125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

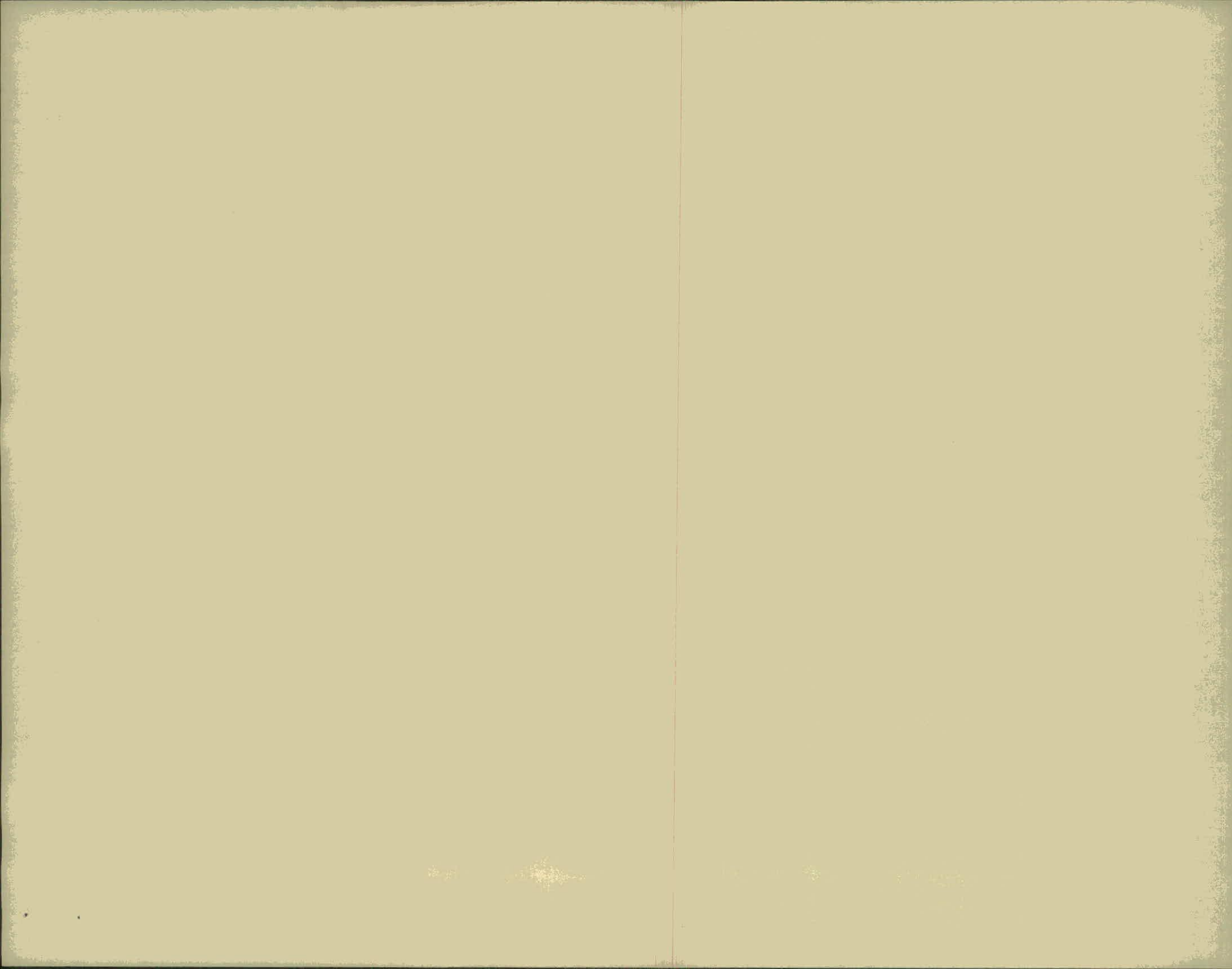
0.13 x 45°
CHAMFER
2PL



RELEASED
2011-08-25

20160329
SA 143940

A		NEW ISSUE		RF	11.02.24	
REV		DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	RF					
CHECKED		DRAWING NO.			REV. A	
MFG. APPR		D4227			SHEET 1 OF 2	
APPROVED		TITLE			SCALE	
DE APPR		RADIUS BLOCK			NTS	
DATE		11.02.24				
COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.						

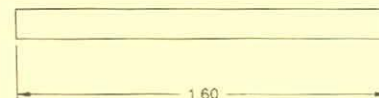
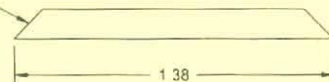


D212-725-1-099 RADIUS BLOCK

NOTES

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC. M6061T6B
OR 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
PER DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

0.13 x 45°
CHAMFER
2PL



0.125

RELEASED
2011-08-25

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR	<i>[Signature]</i>	D4227	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	RADIUS BLOCK	NTS
DATE	11.02.24	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

